



WB22-9-3LT T.I.G. WELDING WIRE

Classifications

AWS A5.9 : ER2209

BSEN 12072 : 22 9 3 N L

Product Description

Standard duplex stainless steel, solid TIG wire.

Applications

WB22-9-3LT finds use in the fabrication and repair of offshore installations and pipework by virtue of its high strength and corrosion resistance, can be used for welding SAF2205, UR45N & AF22.

WB22-9-3LT is extensively used for the repair of 22Cr duplex castings, and yields excellent mechanical properties in the as-welded condition.

Duplex structure of 30-50 ferrite gives a pitting resistance equivalent of >35.

Wire Composition(Weight %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
min.	-	1.0	0.25	-	-	22.5	8.0	3.0	-	0.15
max.	0.03	2.0	0.65	0.020	0.030	23.5	9.5	3.5	0.5	0.20

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm ²	690 min.
Yield Stress/0.2% Proof Stress	N/mm ²	450 min.
Elongation on 5D	%	20 min.
Impact Energy CV @ -50oC as-welded	Joules	>120

Wire Dia (mm)

min.	0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
	-	-	-	-	80	80	80

Current Range (Amps)

max.	-	-	-	-	120	120	120
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Volt Range (Volts)

min.	-	-	-	-	-	-	-
max.	-	-	-	-	-	-	-

Packaging Information

Kg Per Tube

-	-	-	-	2.5	2.5	2.5
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Storage

Storage

It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.

Gases

Gas

Pure Argon

Flow Rate

7-10 l/min

Current Conditions DC- and Welding Positions

